



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE1X53-166-817-7
Job Sheet 189501



Part No: RBE1X53-166-817-7

Job Qty: 8 pcs

Part Name: Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/25/19

Job Tracking No:

Due Date: 2/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE1X53-166-817 Rev.2 IPP Rev. A 19.01.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	8 pcs	2/28/19		0.00	2.00	Large Fab - 1		[Signature]
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	8 pcs	2/28/19		0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	8 pcs	2/28/19		0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S159955



Part: RBE1X53-166-817-7

Job No: 189501

Serial No/Batch: S159955

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 03/07/19

Plex 1/25/19 8:28 AM Dart.lajeunesse.marie

				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
130 Outsource - 12 - Black Oxide	8 pcs	2/28/19		GRO002-VC	03/07/2019 PL
140 Packaging 2-1 - Receive - B4B	8 pcs	2/28/19	0.00 0.00	Packaging 2 - 1 - B4B	
Df				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	OP MAR 13 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
150 QC 6	8 pcs	2/28/19	0.00 0.00	QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	DAS
				QC 6 - 68	MAR 18 2019 68
				QC 6 - 61	9-89
160 Packaging 3-1 - Stock - B4B	8 pcs	2/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
170 QC 21 - SA	8 pcs	2/28/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 MAR 21 2019

Part Op 100 - Weld as per DWG. See note.

Descriptions: 110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required

140 - (Receive & Inspect for Damage & Mat'l Certs) Certificate of Conformity is required

150 - (QC6- All purchased or subcontracted products)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90692A699	SPRING PIN (Steel) Ø1/8 X 7/8	8 (1 ea)	100-Large Fab - Welded Assy-1	150675
RBE1X53-166-817-11	Rod	8 pcs (1 ea)	100-Large Fab - Welded Assy-1	157248
RBE1X53-166-817-9	Rod Top	8 pcs (1 ea)	100-Large Fab - Welded Assy-1	15445

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	90692A699 GA063	8	0	0
	RBE1X53-166-817-11	8	0	0
	RBE1X53-166-817-9	8	0	0

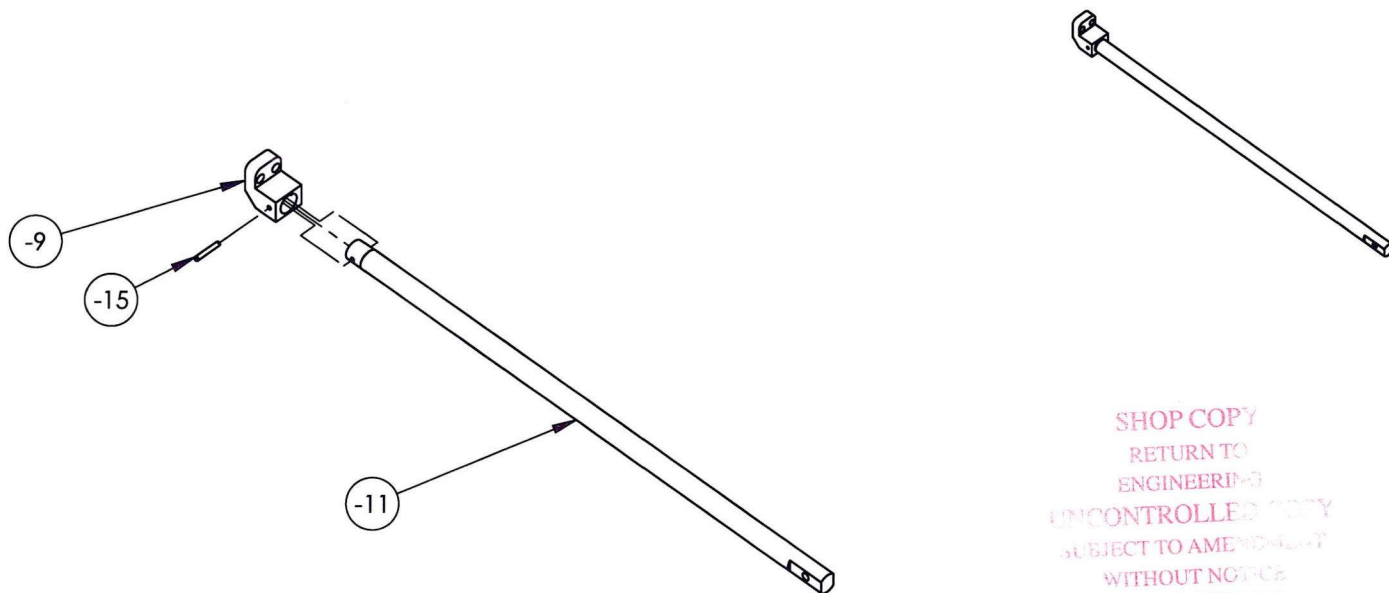
Part Specifications

Specifications could not be found.

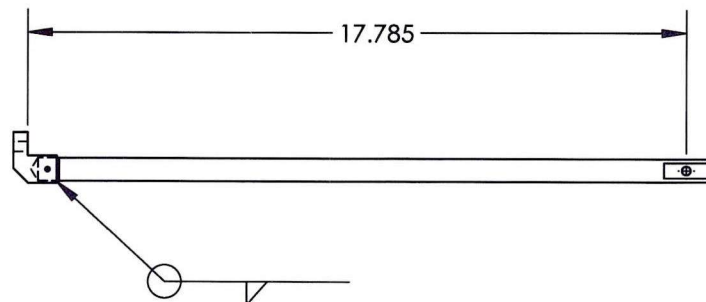
Plex 1/25/19 8:28 AM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0220	-7 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, CH'D DWG. TO SHEET METAL TOLERANCE.	11/14/2016	RJC	SM



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189501 MJS
19-01-25



(-7)
WELDMENT

NOTE:
INSERT -15 SPRING PIN THEN WELD.

DART AEROSPACE																							
TITLE PULLER																							
DWG NO. RBE1X53-166-817-7	REV 2																						
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH BLACK OXIDE</td> <td>XXX ± .010 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC QMSI-6.2.2, B.O. REV D</td> <td>XX ± .03 ANGLES ± 1°</td> </tr> <tr> <td></td> <td>X ± .1 SURFACES = 125/</td> </tr> <tr> <td>DRAWN BY: GILBERT</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>CHECKED: DUERFELDT</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>USED ON MODEL</td> </tr> <tr> <td>APPROVED: MACKOVJAK</td> <td>EC135</td> </tr> <tr> <td>SCALE 1:5</td> <td>DATE 6/18/2012</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH BLACK OXIDE	XXX ± .010 FRACTIONS ± 1/8	SPEC QMSI-6.2.2, B.O. REV D	XX ± .03 ANGLES ± 1°		X ± .1 SURFACES = 125/	DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	QA APPR: LINDSAY	USED ON MODEL	APPROVED: MACKOVJAK	EC135	SCALE 1:5	DATE 6/18/2012
MAT'L	UNLESS OTHERWISE SPECIFIED																						
HEAT TREAT	DIMENSIONS ARE IN INCHES																						
FINISH BLACK OXIDE	XXX ± .010 FRACTIONS ± 1/8																						
SPEC QMSI-6.2.2, B.O. REV D	XX ± .03 ANGLES ± 1°																						
	X ± .1 SURFACES = 125/																						
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R																						
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING																						
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009																						
QA APPR: LINDSAY	USED ON MODEL																						
APPROVED: MACKOVJAK	EC135																						
SCALE 1:5	DATE 6/18/2012																						
SHEET 5 OF 7																							

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042831



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042831
PO Date: 3/7/19
Due Date: 3/14/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	188152	RBEVR-L11-0010-002-B-7	Coupling Nut -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	3/14/19	2 pcs	0 pcs	2 pcs	\$1.93/pcs	\$3.86
Line Item Note **Need parts back for March 14,2019**											
2	189208	RBE350A93-3202-00-22	Bolt -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	3/14/19	6 pcs	0 pcs	6 pcs	\$1.91/pcs	\$11.46



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042831



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Line Item Note **Need parts back for March 14,2019**											
3	189207	RBE350A93-3202-00-21	Support -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	3/14/19	6 pcs	0 pcs	6 pcs	\$1.93/pcs	\$11.58
Line Item Note **Need parts back for March 14,2019**											
4	189204	RBE350A93-3202-00-20	Leg -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	3/14/19	18 pcs	0 pcs	18 pcs	\$1.90/pcs	\$34.20
Line Item Note **Need parts back for March 14,2019**											



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042831



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	191301	269A3150-5-80901	Adapter Lower Cap & T Pin Landing Gear -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	3/14/19	2 pcs	0 pcs	2 pcs	\$1.90/pcs	\$3.80

Line Item Note **Need parts back for March 14, 2019**

6	189501	RBE1X53-166-817-7	Weldment -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	3/14/19	8 pcs	0 pcs	8 pcs	\$1.90/pcs	\$15.20
---	--------	-------------------	---	--------	---	---------	-------	-------	-------	------------	---------

Line Item Note **Need parts back for March 14, 2019**



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042831



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	191694	RBT18546	Wrench for K-Flex Coupling -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	3/14/19	2 pcs	0 pcs	2 pcs	\$1.90/pcs	\$3.80

Line Item Note RUSH * RUSH * RUSH

8	190261	RBW6510A00436W142D-3T-3	Sleeve -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	3/14/19	5 pcs	0 pcs	5 pcs	\$1.90/pcs	\$9.50
---	--------	-------------------------	--	--------	---	---------	-------	-------	-------	------------	--------

Line Item Note **Need parts back for March 14,2019**



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042831



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	190455	RBW6510A00436W142C-3T-11	Pin -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	3/14/19	9 pcs	0 pcs	9 pcs	\$1.90/pcs	\$17.10
Line Item Note **Need parts back for March 14,2019**											
10	190262	RBW6510A00436W142D-3T-5	Socket -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	3/14/19	5 pcs	0 pcs	5 pcs	\$1.90/pcs	\$9.50
Line Item Note **Need parts back for March 14,2019**											
Grand Total:										\$120.00	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042831



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/8/19 10:51 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(017481-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

017481- 2

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
12-Mar-2019		Jessie Boisvert			PO042831			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
6	RBE1X53-166-817-7 Rev.	RBE1X53-166-817-7 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS OIL	OXIDE-BLACK CH	8	18	0	0	DAS 68 9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.